

Date Thursday, 16/08/2007 11:32:37 AM  
User Linda Lacelle

## Process Sheet

*split*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT  
 Job Number : 34026  
 Estimate Number : 12576  
 P.C. Number : *N/A*  
 This Issue : 16/08/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : LARGE FAB ASSY  
 Previous Run : 33579  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev:A New Issue 06-11-09 JLM

Part Number : D3562041  
 Drawing Number : D3562 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : A  
 Material : *N/A*  
 Due Date : 09/09/2007 Qty: *4* Um: Each  
*5*

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>334014</i>

Check Material for any Dents or Defects

*a.m 07.10.04*

*(5)*

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>334485</i>

*07.10.04 5*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562 *a.m 07.10.04*

*(5)*

2-Deburr and bevel ends for welding *a.m 07.10.04*

*(5)*

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

*updated on ECR 987 by RL*

4-Grind end cap welds flush as per Dwg D3562

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/10							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: , Thursday, 16/08/2007 11:32:37 AM  
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Drawing Name: STEP WELDMENT

Job Number: 34026

Part Number: D3562041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 07/10/16

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

*Handwritten:* HX

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*Handwritten:* a.m 07.10.06

*Handwritten:* (5)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* FL 07/10/11

*Handwritten:* (5)

8.0	D3560041	ARM WELDMENT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
ARM WELDMENT

*Handwritten:* B 34474

*Handwritten:* a.m 07.10.11

*Handwritten:* 5

9.0	D3560043	ARM WELDMENT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
ARM WELDMENT

Batch: *Handwritten:* B 34474

*Handwritten:* a.m 07.10.11

*Handwritten:* 5

10.0	MS20600AD4W5	Blind Rivet
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Comment: Qty.: 36.0000 Each(s)/Unit Total : 180.0000 Each(s)  
Blind Rivet

batch: *Handwritten:* M105 65

*Handwritten:* a.m 07.10.11

*Handwritten:* (5)

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.  
Touch-up rivet holes with alodine as per dwg d3562

*Handwritten:* a.m 07.10.11

*Handwritten:* 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:37 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34026

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description

Rivet legs using Magnabond as per dwg D3562.  
Ensure to wipe off any excess magnabond of the step

~~PTD~~

A/R Magnabond 6398

Batch: M104677

Q.M. 07.10.11 (5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



En 07/10/15 (45)  
TEST PIT



Comment: INSPECT WORK TO CURRENT STEP

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M103794

07.10.16 5

2-Grind end cap welds flush as per Dwg D3562

Q.M. 07.10.16

(5)

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07.10.16 (5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/16 (45)

16.0

POWDER COATING

POWDER COATING



M105068



(5X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.B. 07/10/17

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M105684

FL 07/10/18 (5)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/11	11	split up	[Signature]	07/10/11	4		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Job Number: 34026

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-10-24

19.0

D2808

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Spacer

mf 07-10-24

B32752 x 7mx 33mx B32896

20.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

mf 07-10-24

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07-10-24

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Assembly Kit

mf 07-10-24

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

mf 07-10-24

Job Completion



mf 07-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

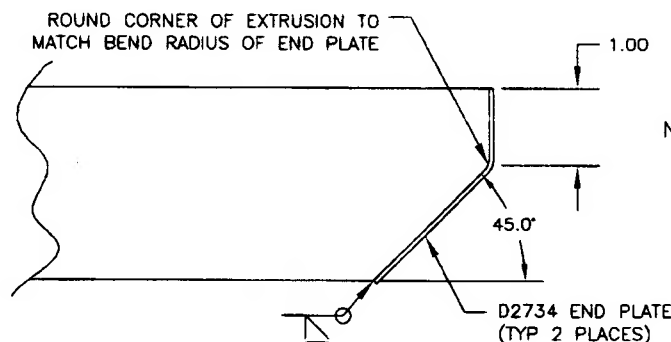
**NOTE:** Date & initial all entries



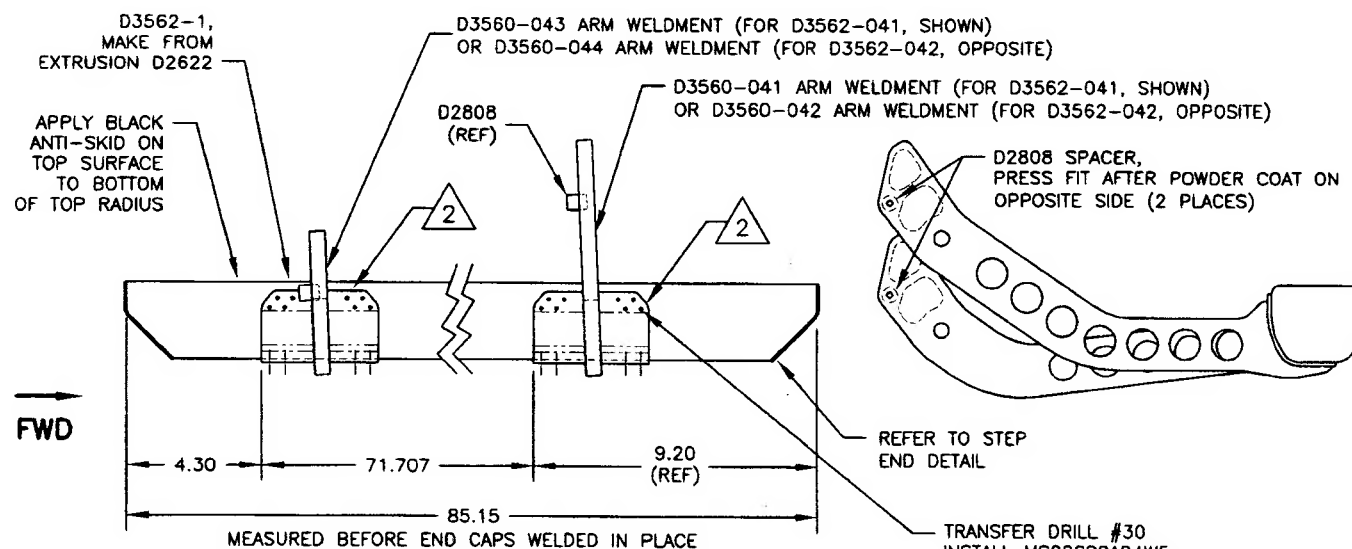


RELEASED  
07.06.21-08

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



**TYPICAL STEP END DETAIL**  
NOT TO SCALE



**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
q/p	q/p	DRAWING NO.	REV. C	
CHECKED	APPROVED	D3562	SHEET 1 OF 1	
DATE	TITLE	STEP ASSEMBLY	SCALE	
07.06.19			NTS	
A	06.09.26	NEW ISSUE		
B	07.01.15	ARMS NOW RIVETED TO STEP		
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTs		